

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24722
<b>Description:</b> Bushing		<b>Part Number:</b>	D3204-7
Dwg: D3204 Rev. A page 2		<b>Qty:</b>	40
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	JF	05/10/31	40
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: <del>AISI 303 SS 0.625</del> Aisi 303 SS 0.625 (M303R0.500) <b>Identify for D3204-7</b> Batch: 113838	ML	05/10/31	40
3	QC2	Inspect parts as they come off the CNC machine <b>Identify as D3204-7</b>	ML	05/10/31	40
4	MC	Deburr	JG	05/11/01	40
5	QC8	Second check	En	05/11/01	40
6	MC	Go to D3204-041 for assembly 2.87 JUC 05/11/19 (80) 2.35	SB	05/11/11	40

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

**RELEASED**

RF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/16

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

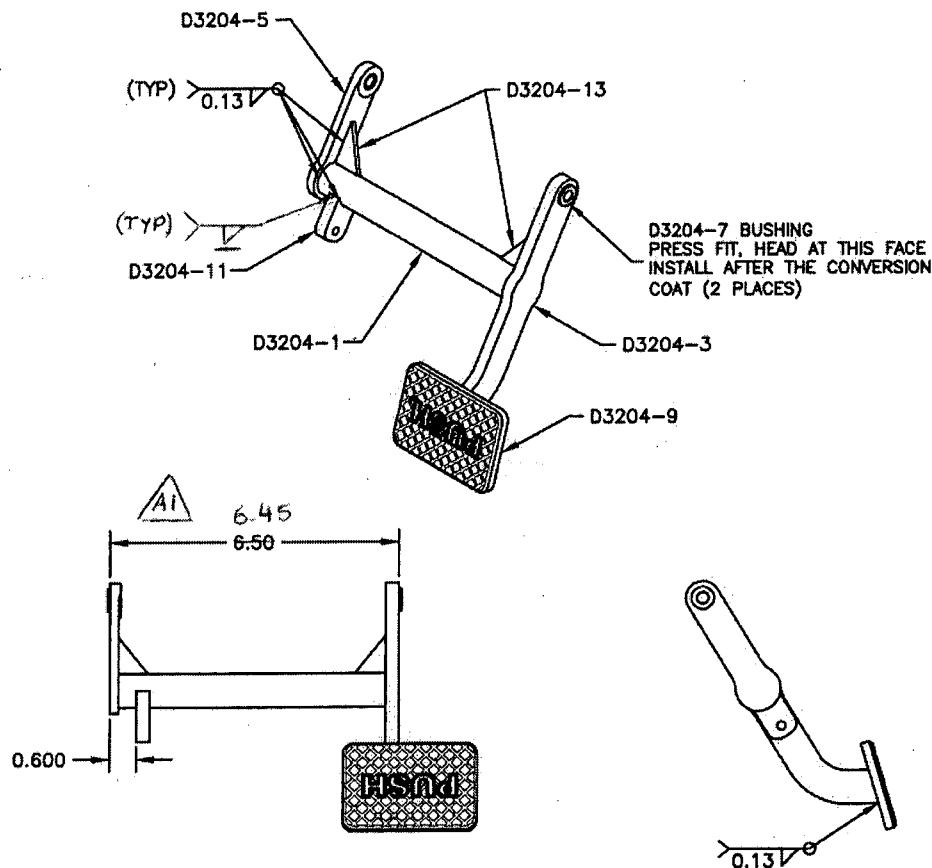
NOTE: Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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WORK ORDER

NO. 24722

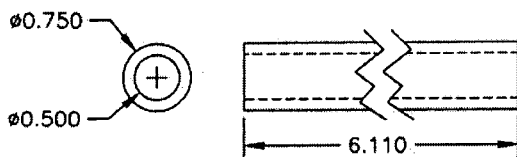
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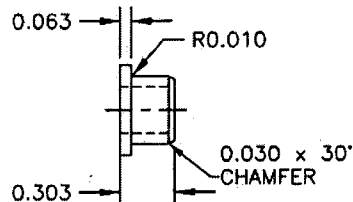


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

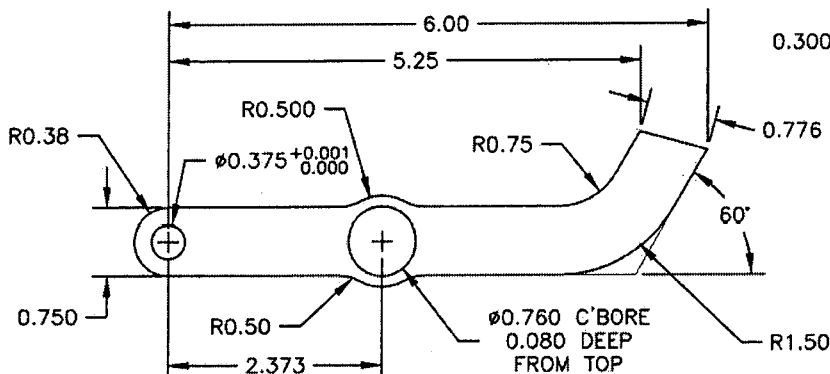
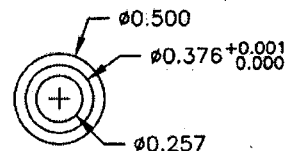
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04.04.05



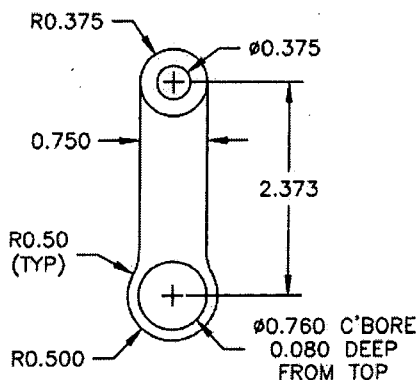
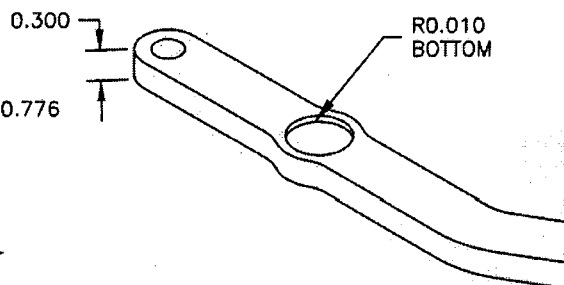
2 D3204-1 TUBE  
SCALE 1:2



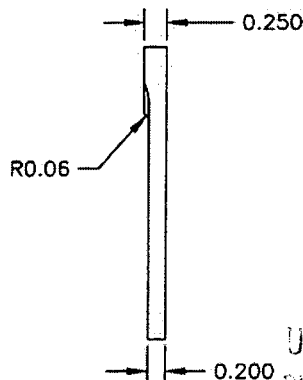
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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WORK ORDER

NO. 24722

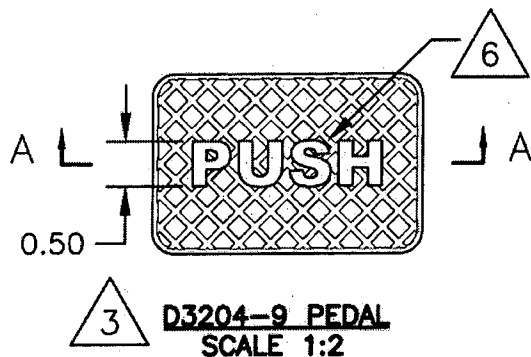
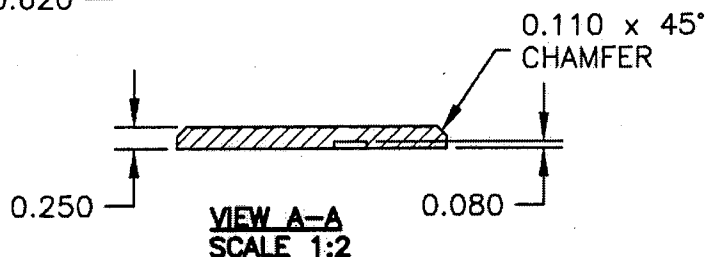
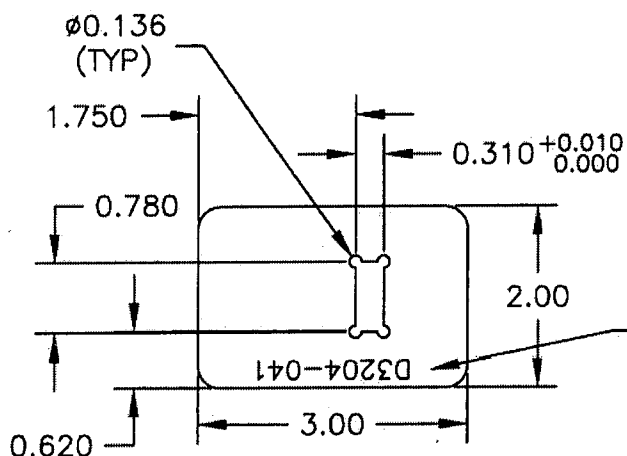
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DESIGN <i>RH</i>	DRAWN BY <i>TH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED  
04.04.30



WORK ORDER  
NO. 24722

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 31, 2005  
12:47 pm

Work Order No : 0024722  
Project Name : D3204-7  
Project For : WK544  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3204-7  
Description : Bushing  
Manufactured : Yes  
Amount Req'd : 40  
Amount Done : 0  
Start Date : 10-31-05  
Est Finish Date : 11-04-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00












Date: Friday, 11/11/2005 7:51:31 AM  
User: Linda Lacelle

# **Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TUBE
<b>Job Number</b> :	24722		
<b>Estimate Number</b> :	10490		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32047
<b>This Issue</b> :	11/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3204 REV A1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
	<b>Type</b> :	<b>Drawing Revision</b> :	A1
<b>Previous Run</b> :		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	11/18/2005
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	40
<b>Comment</b> :	Est:B 04.06.09 Change Step 6; remove Steps 7 & 8 KJ/RF		

## **Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M303R0500	303 Round Bar 0.500"
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
 		
<b>Comment:</b> HARDINGE CNC LATHE SMALL 1-Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 		
<b>Comment:</b> SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____		
6.0	DC	DOCUMENT CONTROL
 		
<b>Comment:</b> DOCUMENT CONTROL Inspection Level 21		
Job Completion 		



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:46 pm

Work Order No : 0024722  
Project Name : D3204-7  
Project For : WK544  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3204-7  
Description : Bushing  
Manufactured : Yes  
Amount Req'd : 40  
Amount Done : 0  
Start Date : 10-31-05  
Est Finish Date : 11-04-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	5.75	100.00		
Production Cost :	0.00	111.09	100.00	0.00	111.09
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	5.75	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	111.09	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	111.09			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -111.09)